

March 30, 2016 12:53:01 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D206-581	D	MLJ 16-03-3)

100 Document Control 0.00

100

DC	Memo	0.00
----	------	------

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD206-581-015 CHG001

DAS
28
9-89

MAR 31 2016

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
-----------	------	------

Packaging

ML5 DAS/6-03-30
28
9-89

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
----	------	------

Quality Control

DAS
28
9-89

MAR 31 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 144026

March 30, 2016 12:53:01 PM

144026

Page 2

Item ID: D206-581-015

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Step Handle, Fits LH or RH

Stop ***NS2***

Start Date: 3/31/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						DAS		MAR 31 2016	
Packaging	Memo	0.00				28			
Packaging	Identify and pack for shipping as per PPP D206-581-015 Location : FG018					9-89			
140	QC21- Final Inspection - Work Order Release	0.00							
140								APR 01 2016	
QC	Memo	0.00							
Quality Control									

ML
16-3-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Picklist Print

March 30, 2016 12:53:05 PM

Page 1

Work Order ID: 144026

144026

Parent Item: D206-581-015

D206-581-015

Parent Item Name: Step Handle, Fits LH or RH

Start Date: 3/31/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev:A New Issue 10-07-16 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4103-1		Manufactured	No			110	Each	1.0000	1	1			

D4103-1

Step / Handle

MLJ 16-03-30

Location

Loc Qty

Loc Code

ST080

1

140595

1

80-005-3-8

Purchased

No

110

Each

26.0000

2

2

80-005-3-8

INSERT

MLJ 16-03-30

Location

Loc Qty

Loc Code

ST585

26

M133990

26

MS27039-4-11

Purchased

No

110

Each

47.0000

2

2

MS27039-4-11

Screw

MLJ 16-03-30

Location

Loc Qty

Loc Code

ST279

47

m133990

47

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

Picklist Print

March 30, 2016 12:53:05 PM

Page 2

Work Order ID: 144026

144026

Parent Item: D206-581-015

D206-581-015

Parent Item Name: Step Handle, Fits LH or RH

Start Date: 3/31/2016

Required Date: 4/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

110

Each

4,288.000

2

2

NAS1149D0416.I

WASHER

MLJ 16-03-30

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	248	
m131511	248	
ST260a	1984	
m131511	1984	
ST264	2056	
m131511	2056	2

NAS1149D0463J

Purchased

No

110

Each

4,336.000

2

2

NAS1149D0463.I

WASHER

MLJ 16-03-30

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	149	
M129390	41	
M132035	108	
ST260a	2000	
M134573	2000	
ST263	1199	
M134039	1199	2
ST269	988	
M132317	100	
M132677	888	

March 30, 2016 12:53:05 PM

Shop Packet Print

Page 2

DART AEROSPACE LTD.

D206-581
Page 20 of 21

DAS
28
9-69

5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				X		D206-581-015	STEP HANDLE KIT
						X	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
	1						D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						2	80-004-2D8	INSERT
					2		80-005-3-8	INSERT
		6	6	6			80-005-3-16	INSERT
						8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
	6	6	6				MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
	6	6	6		2		NAS1149D0416J	WASHER (or AN960JD416L)
					2		NAS1149D0463J	WASHER (or AN960JD416)

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Revision: D
Date: 12.08.23